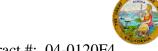
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: <u>04-0120F4</u>

Cty: <u>SF/ALA</u> Rte: <u>80</u> PM: <u>13.2/13.9</u>

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary Report No: WIR-000925

Address: 333 Burma Road Date Inspected: 21-Nov-2007

City: Oakland, CA 94607

Project Name:SAS SuperstructureOSM Arrival Time:1300Prime Contractor:American Bridge/Fluor Enterprises, a JVOSM Departure Time:2330

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island Location: Shanghai, China

Xu Lefang, Sun Wei and Sha Zi CWI Present: **CWI Name:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A

Delayed / Cancelled: Yes No N/A **Bridge No:** 34-0006 Component: 77, 89, 114 Meter Mock-Up & OBG

Summary of Items Observed:

Mock-Up 77

This Quality Assurance Inspector observed ZPMC welders Xu Wei, welder identification 066253, Li Zheng Xu, welder identification 066179 and Guo Deng Yon, welder identification 037997 welding with shield metal arc welding electrode EP-E9018 H4R. Welding was being carried out on the MUA SA95 Diaphragm with welding procedure specification WPS-B-T-3312-TC-P5. Welding variables were checked and found to be 246 Amps, 24 volts, Travel Speed 139 millimeters per minute and a pre-heat of 192 degrees Celsius.

Mock-Up 89

This Quality Assurance Inspector observed tack welding of MUSB MA23, Skin Plate C weld joints. ZPMC welders were Wang Zhonqhua, welder identification 053753 and Dai Lo, welder identification 048659.

Mock-Up 114

This Quality Assurance Inspector observed welding of the Skin B connection plate weld joint 2A in the flat position by ZPMC welder Jiang Zhou, welder identification 040261. Some of the essential welding variables were checked and found to be 295 amps, 32 volts, travel speed of 330 millimeters per minute and a pre-heat of 130 degrees Celsius.

OBG

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This Quality Assurance Inspector observed ZPMC welder Gung Zhi Wu, welder identification 059405 finishing the tack welding of the long and short deck plates MU3 together. There was no weld number assigned or a shop drawing available for review.



Summary of Conversations:

No conversations held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

| Inspected By: | Berger,Bruce | Quality Assurance Inspector |
|---------------|--------------|-----------------------------|
| Reviewed By: | Cochran,Jim | QA Reviewer |